

# Work Order ID 57427

April 6, 2010 4:00:30 PM



Page 1

Item ID:	D3852-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly				Stop	
Start Date:	06/04/2010	Start Qty:	2.00			
Required Date:	12/04/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10-4-06	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3852	Rev A								

100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig								
	2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852								
	3- c'sink hole as per dwg								
	4- remove identification markings								
	5- deburr								
	6- weld D3759-1 bushing as per dwg D3852 A/R ER316 S.S. Rod Batch: <u>M109213</u>								
	7- grind bushing weld flush as per dwg dwg D3852								
	8- deburr hole if necessary								

SAD 10-04-08

② PD 10.04.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57427

April 6, 2010 4:00:30 PM



Page 2

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*6/10/04/12*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*8/10/04/12*

*(+2)*

150

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

*SAD*  
*10-09-12*

*2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 57427**

April 6, 2010 4:00:30 PM



Page 3

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 *[Signature]*Bl 10-4-12  
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April 6, 2010 4:00:35 PM

Page 1

Work Order ID: 57427

Parent Item: D3852-041

Parent Item Name: Rib Assembly

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC


Start Date: 06/04/2010

Required Date: 12/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3166-3  Basket Hoop		Manufactured	No			100	Each	9.0000	0.3789			
--	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

SAD 10-04-02

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

9


55697

3

56426

6

0.3789

D3759-1  Bushing		Manufactured	No			100	Each	25.0000	2.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

25

54072

9

57184

16

PD 10.04.03

402

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

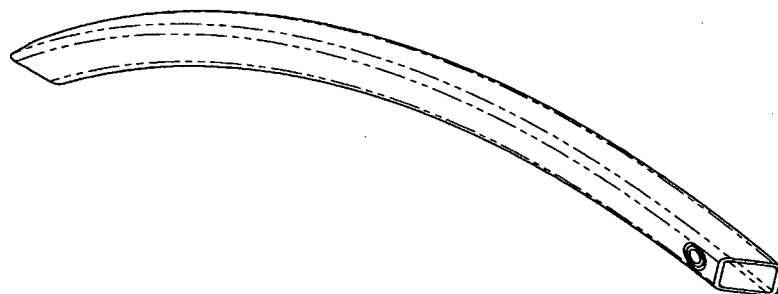


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



**D3852-041 RIB ASSEMBLY**



**D3852-042 RIB ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57427

*BS 10-404*

RELEASED  
*est/18 MP*

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.83 lbs EACH
  - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

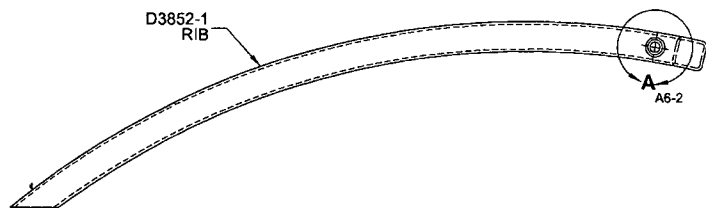
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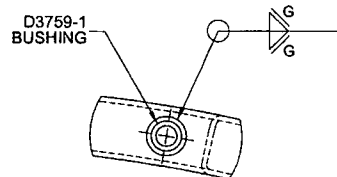
**NOTE:** Date & initial all entries



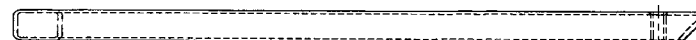
D3852-1  
RIB



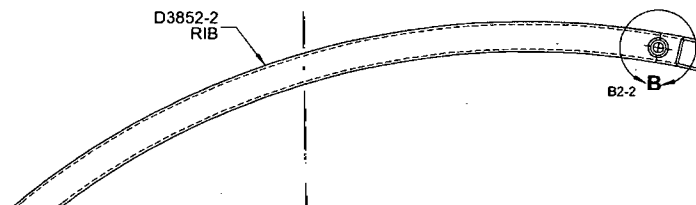
**D3852-041 RIB ASSEMBLY**



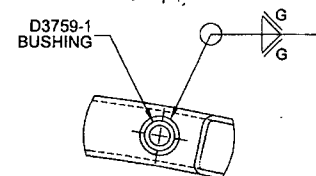
**DETAIL A**  
SCALE 2X C5-2



D3852-2  
RIB



**D3852-042 RIB ASSEMBLY**



**DETAIL B**  
SCALE 2X C2-2

W/O 51427

**RELEASED**  
08/11/07

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.		<b>D3852</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

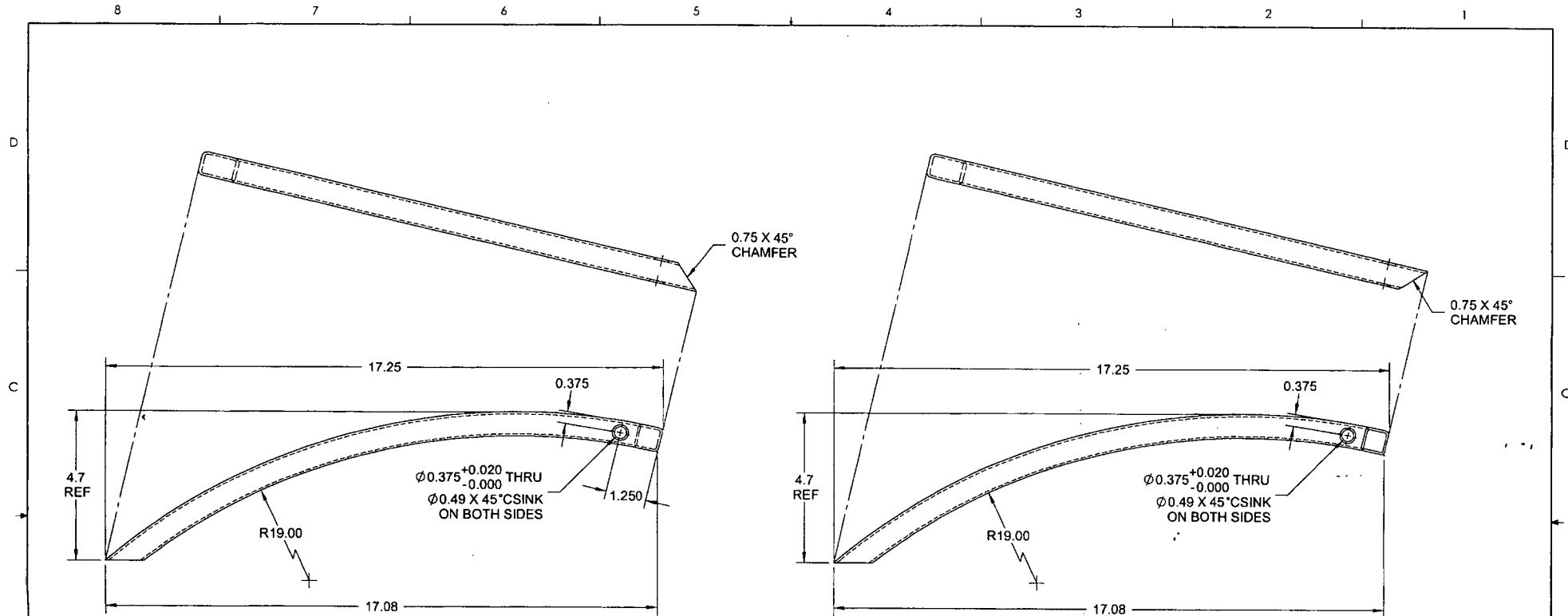
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**D3852-1 RIB**

**D3852-2 RIB**

w/o 57427

**RELEASED**  
08/11/84

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D3852</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB ASSEMBLY</b>	NTS
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